

Work Order ID 64565-1

Wednesday, December 08, 2010 10:27:10 A

Split



Page 1

Item ID: D3805-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 12/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

AL

Date: 10-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DRAWING WAS NOT UNDER REVIEW ON 11-05-19.
ACCEPTABLE TO CONTINUE WORK PER REV. A
THIS BATCH WILL. 0.00 11-05-20.

D3805

Rev A

100



Large Fab

Large Fab

Memo

0.00

1- on D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH # *M 12 105 2*

2-weld D3806-1 to wearplate by positioning holes together as per dwg D3805
304 SS Welding Rod
BATCH # *M 12 105 2*

3-Transfer drill holes in bar

QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

jenasie

11-5-9

JD

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Page 2

Item ID: D3805-041

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Required Date: 12/22/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/C

0.00



QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4 3

0.00



Powdercoat

Powder Coating

Memo

START TIME.

OVEN TEMPERATURE

FINISH TIME.

0.00

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



6x Ø M-1 11/05/12

6 BR 11-5-12

M115128

9:30
320
10:55

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Page 3

Item ID: D3805-041

Revision ID:

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 12/8/2010 Start Qty: 6.00

Required Date: 12/22/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Small Fab

Small Fab

Memo

0.00

1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300F scotch grip adhesive as per dwg

BATCH: 1115230

SA 11/06/01 9

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subtotal

(+4)

170



Packaging

Packaging

Identify as per dwg & Stock Location

FR29

0.00

Memo

0.00

x4 6 all 11/06/01

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Page 4

Item ID: D3805-041

Revision ID:

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 12/8/2010 Start Qty: 6.00

Required Date: 12/22/2010 Req'd Qty: 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/6
MF
11-06-01

Picklist Print

Wednesday, December 08, 2010 10:27:14 AM

Page 1

Work Order ID: 64565

Parent Item: D3805-041

Parent Item Name: Wearplate Assembly, Fwd. Low Gear



Start Date: 12/8/2010

Required Date: 12/22/2010

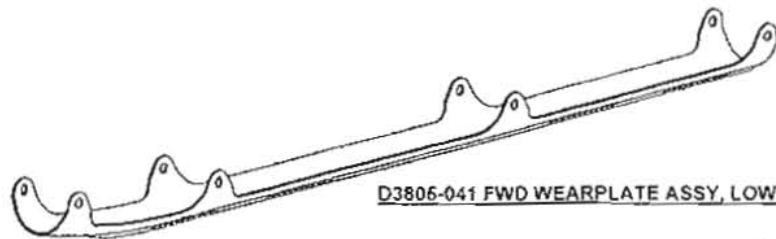
Start Qty: 6.00

Required Qty: 6.00

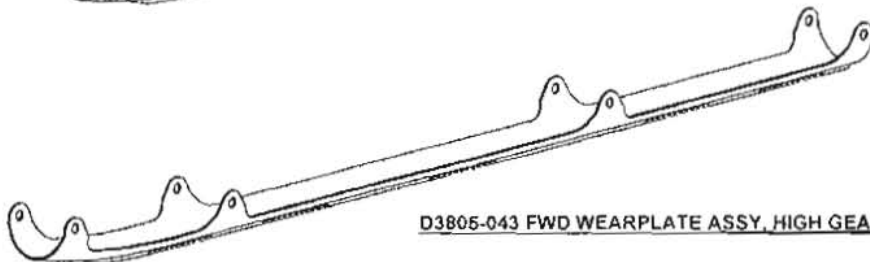
Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04
rev.a as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-1 		Manufactured	No			100	Each	0.0000	1	6			
Plate					64574x6							EL 11-4-12	
D3806-1 		Manufactured	No			100	Each	0.0000	1	6			
Bar					67843x6							EL 11-4-12	
D3807-1 		Manufactured	No			150	Each	0.0000	1	6			
Gasket					56158D							SD 11/06/10	

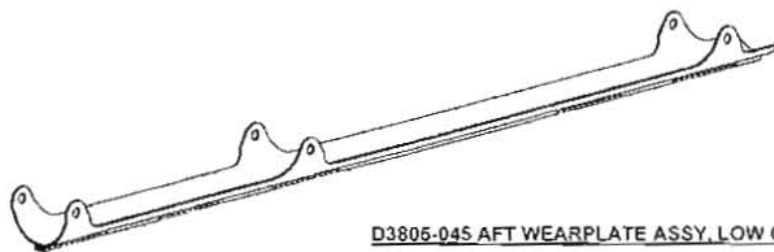
8 7 6 5 4 3 2 1



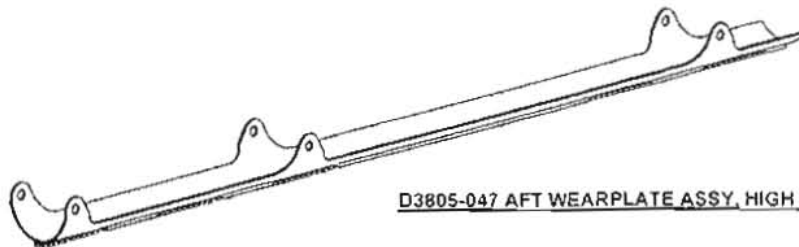
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D 185-043	FWD WEARPLATE ASSY, HIGH G- R
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3805-1	BAR
16		1			D3805-3	BAR
17			1		D3805-5	BAR
18				1	D3805-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2050B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1302)	3M SCOTCH-GRIP ADHESIVE

ISSUED BY
DATE
ENGINEER
UNCONTROLLED COPY
SUBJECT TO CANCELLATION
WITH NO NOTICE
WORK ORDER
NO. 64545
B-110-12-B

RELEASED
97-03-02
JAN 09-98

DESIGN	REV	DESCRIPTION	DATE
DRAWN	1	DART AEROSPACE USA, INC.	08.11.21
CHECKED	2	PORT HADLOCK, WA	
MFG. APPR.	3	DRAWING NO. D3805	REV A
APPROVED	4	TITLE WEARPLATE ASSY	SHEET 1 OF 8
DATE	08.11.21	SCALE	NTS